

Work Order ID 74888

74888

Page 1

October 13, 2011 11:20:06 AM

Item ID: D3806-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 10/13/11 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 11/15/11 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/13 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3806	B

100 0.00
100
 Cold Saw Memo
 Hyd Mech Cut blanks at 43.600"
 FK- 11/11/08 20

110 0.00
110
 HAAS 1 Memo
 HAAS CNC vertical machine #1 1-Mill as per folio FB070 & dwg
 FOLIO REV: B
 DWG REV: B
 2-Deburr as required
 FK 11/11/08 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u>20</u>			
			FK- 11/11/08						
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>20</u>			
			SA 11/11/09						
133 *133* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: _____ Memo 1- On D3806-1, fill cut outs with hardcoat welding rod as per dwg D3805 2059 B Hardcoat Welding Rod BATCH#: _____	0.00 0.00							

will be done on assembly w/o

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
136 *136* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo <i>N/A</i>	0.00 0.00							
137 *137* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>W/A</i> Memo	0.00 0.00							

will be done on assembly w/o

11/1/29 20

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Work Order ID 74888***74888***

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Item ID: D3806-1

Accept

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Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 10/13/11 Start Qty: 20.00

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Cust Item ID:

Required Date: 11/15/11 Req'd Qty: 20.00

20

Customer:

Reference:

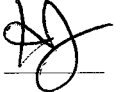
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

11/11/30 JMR
11-11-29

Dart Aerospace Ltd

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Picklist Print

October 13, 2011 11:20:11 AM

Page 1

Work Order ID: 74888

74888

Parent Item: D3806-1

D3806-1

Parent Item Name: Bar

Start Date: 10/13/11

Required Date: 11/15/11

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A 08-07-21 new issue DD verified by:ec

IPP Rev:B 08-09-23 redesign DD verified by:EC

IPP Rev:C 08-09-30 redesign DD verified by:EC

D 11.06.03 re-design EC verified by:DD

rev.b as per dwg DD verified by:EC

IPP rev
IPP Rev:E 11.10.04

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B0.250x0.500

Purchased

No

100

f

1,482.142

3.66

77.05263

M304B0 250x0 500

**

FK - 11/11/08

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT006

1421.128

117842

8.3

119050

21.67

119159

1391.158

MAT050

61.0147

117176

61.0147

77.053

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

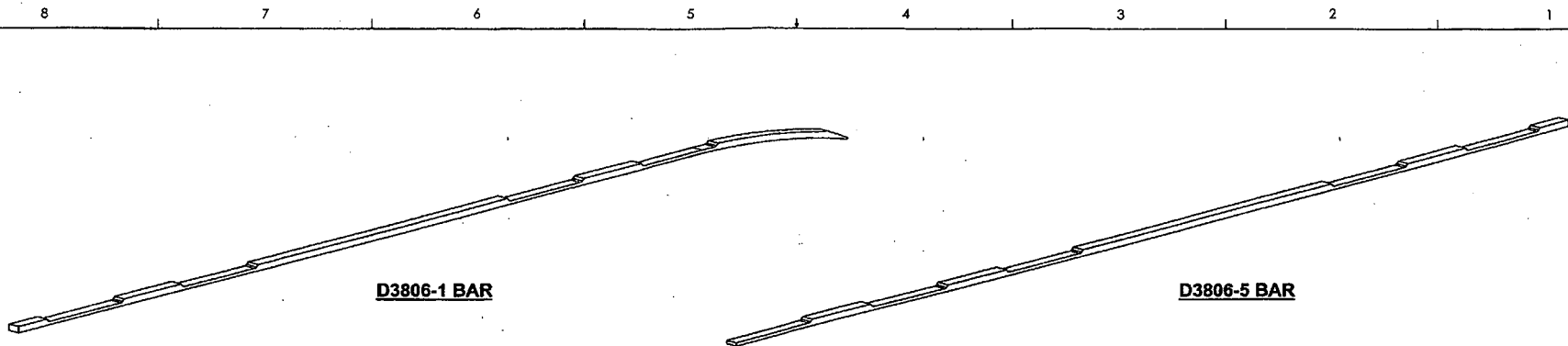
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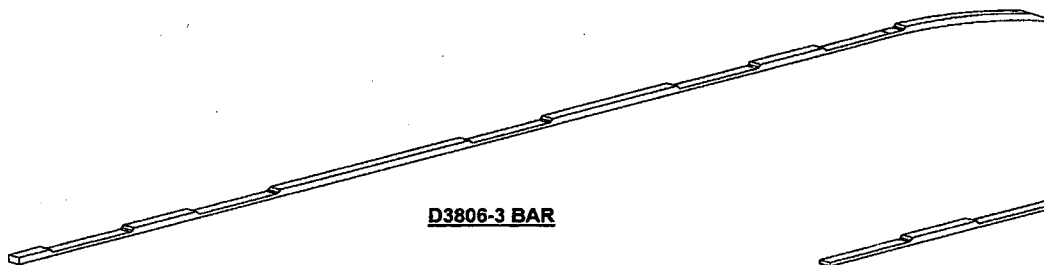
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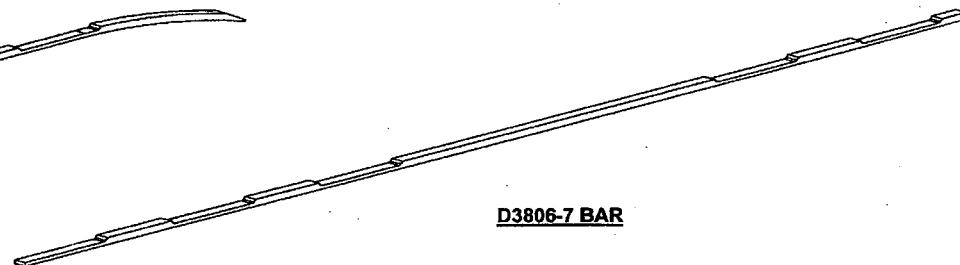


D3806-1 BAR

D3806-5 BAR



D3806-3 BAR



D3806-7 BAR

RELEASED
2011-10-03

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 74888 M.L.J
11/10/12

B	REVISED D3806-1/3 TO EASE MANUFACTURABILITY: 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/3/5/7 PER PAR11-106	MB	11.09.29
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	11.09.29	<small>COPYRIGHT © 2004 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

Dart Aerospace Ltd

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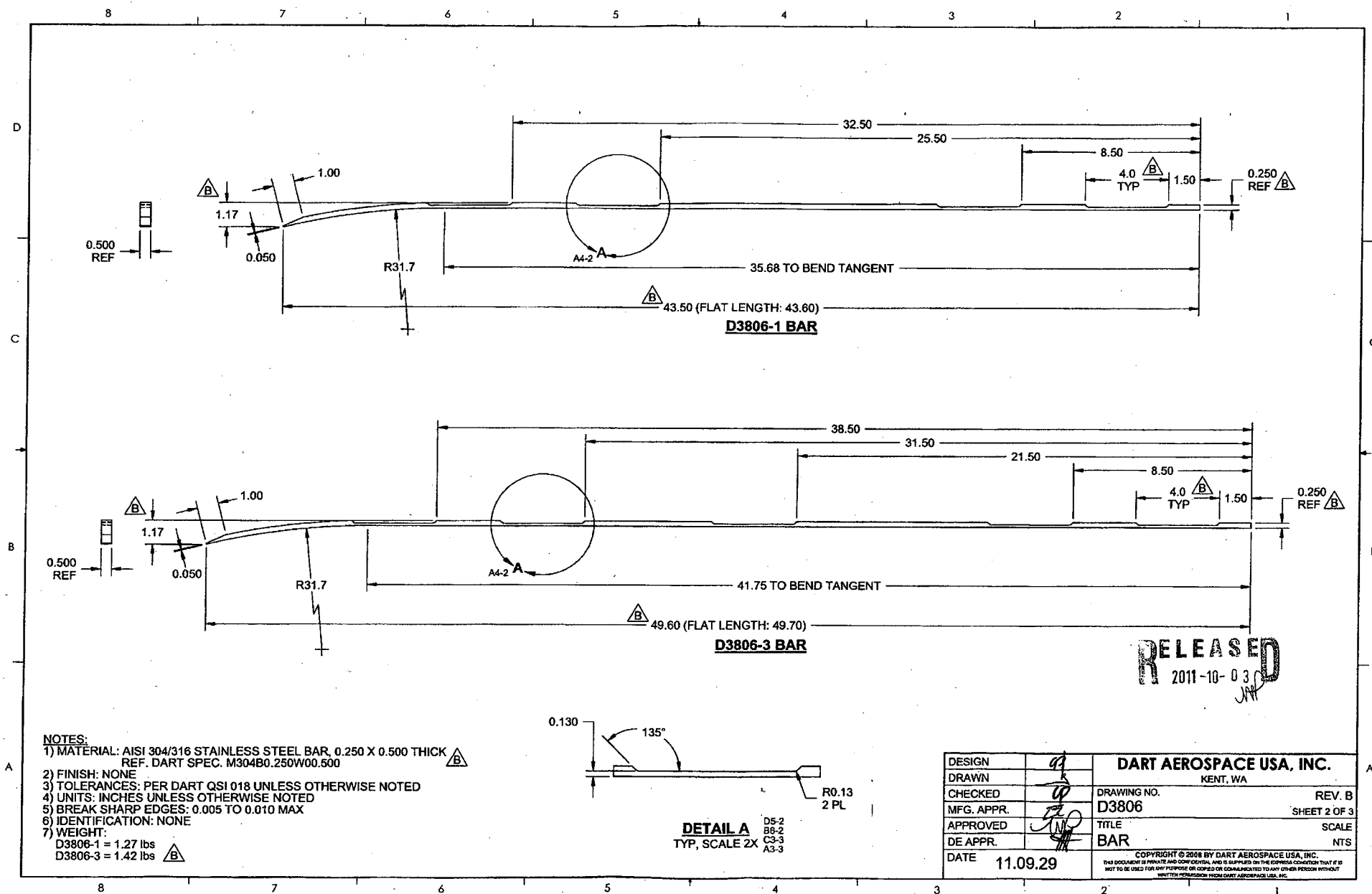
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74888

FLB63



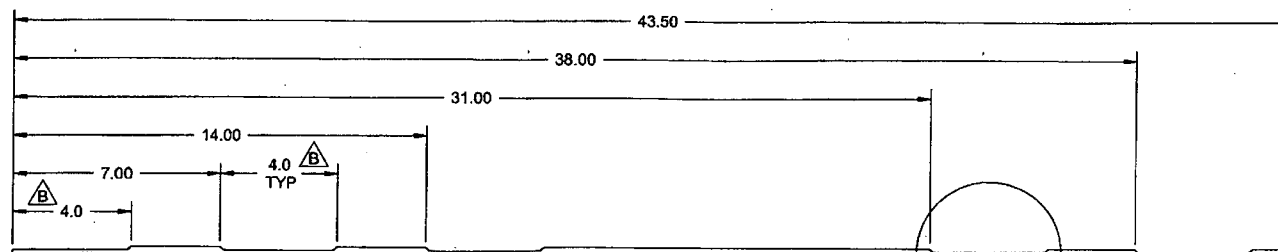
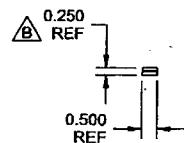
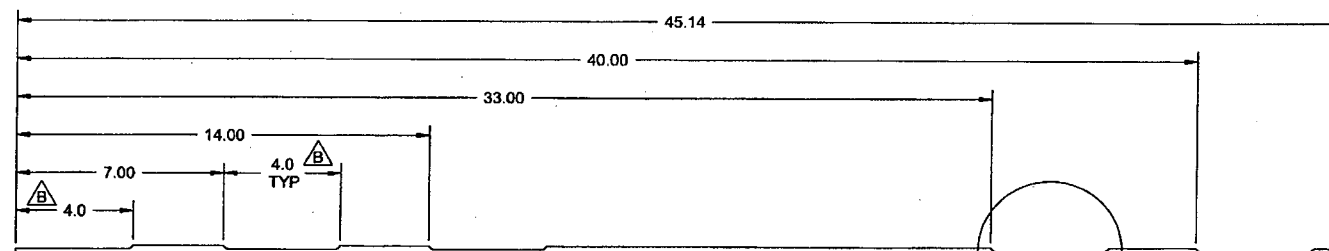
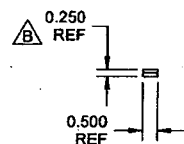
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~~74888~~**D3806-5 BAR****D3806-7 BAR**

RELEASED

2011-10-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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